	er ID 122876 , 2014 2:24:56 PM		*122	2876*						Page	1
Revision ID:	D3580-3 Joggle Bracket		Accept	*N900	0040	100	)* ፡	Setup Sta	1/1	S1* S2*	
Start Date: Required Date: Reference:	8/29/14 Start Qty: 20.0 8/29/14 Req'd Qty: 20.0	7 ( )		Cust Item Customer:							
Approvals:	Process Plan: wm	Date: ☐/30/14 Date:	Tooling: SPC (Y/N):		ate:		I	Run Sta Sto	<b>^ \</b>	R1*	
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr										
D3580	С						•				
*100 *100* Waterjet FLOW CNC Waterje	Dwg Re Prog Re	3580-1F as per Dwg	0.00	:			20			DAS 23 9-89	14-10-2
*110 *110* QC Quality Control	QC2- Inspect parts o	ff machine FAI/FAIB	0.00				_ 2°_	_۵_		DAS 23 9-89	_14-10-7
120 *120*	QC8- Inspect parts -	second check	0.00				(20)	)		DAS <b>38</b> 9-8:	
*	Memo		0.00				· /				

Quality Control

DQA:			Date:											PT
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·	· -					Rework			Skid-tube	Crosstube	1	Water Jet	Engineerin	ng 🗍
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	-					Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging	Othe	er 🔲
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		Bending				Bend	L	Folio/F	rogram		Outside Dim	ensions	Pressure/Ford	ced
		Centre N	ot Concer	itric	_	BOM/Route	_	Grain			Over/Under		Set-up	
		Cracks				Broken/Damage/Defect	_	Hardwa		<u> </u>	Part Incorre	<del> </del>	Temperature,	/Cure
	Щ	Crimp/Kii	nk/Ripple	/Wave		Burrs		1	ion Incomplete/U	· ·	Part Lost/Mi	ssing	Weld	
	Ь	Cuffs			<u> </u>	Contamination		-4	ions Incomplete/I	Unclear	Part Moved	L	Wrong Stock	Pulled
	Ш	Crushing		, -		Countersink	<u> </u>	1	ned/off center		Positioned V		<b>-</b>	
	Щ	Heat Trea				Cut Too Short	L	Mislabe		. L	Power Loss/	Surge	Other	
	-	Inspectio	-	Tube	<u> </u>	Drawing	$\vdash$	Misrea			-			
		Marks/Cl			$\vdash$	Drill Holes		Off-set				<u></u>		
	Щ		Sequence		-	Finish	$\vdash$	4	Calibration		-			
	1	Wave/Tw	vist in Tub	e	l_	Fit/Function	1	Out of	Sequence					

W	ork	Order	ID	122876
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Tuesday, July 29, 2014 2:24:56 PM

## \*122876\*

Page 2

Item ID:

D3580-3

Accept

\*N900040100\*

Setup Start

Stop

**Revision ID:** 

**Start Date:** 

Required Date: 8/29/14

**Item Name:** Joggle Bracket

8/29/14

**Start Qty: 20.00** Reg'd Oty: 20.00 \*20\*

**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start Run

Stop

Sequence ID/ **Work Center ID** 

**Operation** Description

Set Up/ **Run Hours** 

Tool ID

Tool # Plan Code

DAS

30

9-89

Accept Qty

20

Reject Reject Qty

OCT 0 8 2014

Insp. Number Stamp

130

\*130\* Small Fab

Small Fab

Memo

0.00

0.00

Small Fab

Bend as per dwg D3580 using 1/8" offset die

140

\*140\*

Quality Control

OC

QC5- Inspect part completeness to step on W/O

0.00

0.00

DAS

145

\*145\*

Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Memo

Memo START TIME:

OVEN TEMPERATURE: FINISH TIME:

0.00

20 \$ 14-18-8

DQA:			Date:						_				
QA Closed:			Date:			WORK ORDER NON-	·CC	ONFO	RMANCE / UI		ork Order up	odate only	AEROSPACE
						DISPOSITION				AGAINST DE			
Work Orde	er: _									_	7		¬
Part N	lo.					'Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo.				<u> </u>	Suspected Unapproved			Large Fab	Composite	]	Supplier	
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Cause	,	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
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		Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorre	લ	Temperature/Cure
		Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified	Part Lost/Mi	ssing	Weld
		Cuffs				Contamination		4	ions Incomplete/U	Jnclear	Part Moved	<u> </u>	Wrong Stock Pulled
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		Heat Trea			ļ	Cut Too Short	L	Mislabe			Power Loss/	Surge	Other
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		Marks/Cl	natter		<u> </u>	Drill Holes	L	Off-set					
		Turning S	Sequence			Finish	L	4	Calibration				
	1	Wave/Tw	vist in Tub	oe		Fit/Function		Out of 9	Sequence				

<u> </u>													
Work Orde Tuesday, July 29					*122	2876*					-		Page 3
Item ID: Revision ID: Item Name: Start Date: Required Date: Reference:	D3580-3 Joggle Bracke 8/29/14 8/29/14	Start Qty: 20.00 Req'd Qty: 20.00		20* 20*	Accept	*N900 Cust Item Customer:		100	<b>)*</b> s	Setup	Start Stop	IV	S1* S2*
Approvals:	Process Pla	in:	Date:		Tooling: _ SPC (Y/N):		ate:		F	Run	Start Stop	<b>^!</b> \(\mathbb{I}\)	R1* R2*
Sequence ID/ Work Center II  147  *1 47* QC  Quality Control	)	Operation Description QC3- Inspect Part Finish Memo			Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp DAS 38 9-89 14-16
148 *1 4 Q* QC Quality Control		QC5- Inspect part comple	teness to step on	W/O	0.00				(26)				DA: <b>38</b>   4-10-1

150

Identify as per dwg & Stock Location: 54050 0.00

\*150\* Packaging

Memo

0.00

Packaging

DQA:			Date:										7	
OA Classide			Data			WORK ORDER NON-	-CC	ONFO	RMANCE / U		Work Order	update only		AEROSPACE
QA Closed:			Date:								WORK Order	upuate only		
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	-					Use-as-is			noforming	Finishing	Rec/S	tore/Packaging		Other
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		Bending			L	Bend	⊢	4	Program			Dimensions	$\boldsymbol{\vdash}$	essure/Forced
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		Crimp/Ki	nk/Ripple	/Wave	$\vdash$	Burrs	<u> </u>	1 '	ion Incomplete/Ui	· 1	Part Lost	_	Щw	
		Cuffs			<u> </u>	Contamination	<u> </u>	- 4	tions Incomplete/	Unclear	Part Mov		ШМ	rong Stock Pulled
	_	Crushing			<u> </u>	Countersink	<u> </u>	- '	gned/off center		Positione	_		1
1		Heat Trea			<u> </u>	Cut Too Short	L	Mislabe		l	Power Lo	ss/Surge	Ot	her
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		1	Sequence		Ļ	Finish	L	-1	Calibration				•	
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Work Ord Tuesday, July 2				*12	2876*		* 1					Page 4
Item ID: Revision ID: Item Name:	D3580-3  Joggle Bracke	it		Accept	*N9000	<b>140</b>	100	)*	Setup	Start Stop	171	S1* S2*
Start Date: Required Date: Reference:	8/29/14 8/29/14	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item ID Customer:	<b>)</b> :					I	17
Approvals:	Process Pla	nn:	Date:	Tooling: SPC (Y/N):	Dat				Run	Start Stop		R1* R2*
Sequence ID/ Work Center I	D	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp

0.00

Memo

**Quality Control** 

\*160\*

Number Stamp

14 W H

DQA:			Date:										`	TRAC
QA Closed:			Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UF		ork Order up	ndate only	7	AEROSPACE
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Part N	۱o.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.		Quality
	-					Use-as-is		Therr	noforming	Finishing	Rec/Stor	re/Packaging		Other
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		Centre N	ot Concer	ntric		BOM/Route	Г	Grain			Over/Under	tolerance	∏s	et-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ci 📗	T	emperature/Cure
		Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified	Part Lost/Mi	ssing	v	Veld
	П	Cuffs				Contamination		Instruc	tions Incomplete/U	Jnclear	Part Moved		v	Vrong Stock Pulled
		Crushing				Countersink		]Misaliį	gned/off center		Positioned V		_	
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	Surge	c	ther
		Inspectio	n Strip in	Tube		Drawing		Misrea	d					
		Marks/Cl	natter			Drill Holes		Off-set						
		Turning S	Sequence			Finish		Out of	Calibration		-			
		Wave/Tv	vist in Tub	oe		Fit/Function		Out of	Sequence					

## **Picklist Print**

Tuesday, July 29, 2014 2:24:55 PM

Work Order ID: 122876

\*122876\*

Parent Item:

D3580-3

\*D3580-3\*

Parent Item Name: Joggle Bracket

**Start Date:** 8/29/14

Required Date: 8/29/14

Page 1

**Start Qty: 20.00** 

Required Qty: 20.00

Comments:

IPP REV:A 14.07.03 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No	-			sf	629.9700					DAS
*M304S18	RGA*								**				23 9-89 (U -

304/316 .050 Sheet

<b>Location</b>	Loc Qty	Loc Code	
MAT019	617.97		
117188	3		
117766	5		
120604	5		
122325	3		
123155	3		
124572	38		
M126647	31.55		
M128254	90.17		
M128435	123.25		
M128864	64	•	
M129530	252		129530
MAT020	12		<u> </u>
124029	2		
M126098	10		

DQA:			Date:										"DAR"	T
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / U		Work Order	update only	AEROSPAC	; Ē
						DISPOSITION				AGAINST [	EPARTMEN	IT/PROCESS		
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Part N	۱o. <sub>-</sub>					Rework Scrap		ļ	Skid-tube Machining	Crosstube Small Fab	_	rod. Eng. Coor.	Engineering Quality	- - -
NCR N	10.				<del></del>	Use-as-is Suspected Unapproved			noforming Large Fab	Finishing Composite	Rec/s	tore/Packaging Supplier	Other	}
Root					Desc	ription of work order update		nitial	Ac	tion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	n QC Inspector	
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		Bending				Bend		Folio/F	rogram	[	Outside D	imensions	Pressure/Forced	
		Centre N	ot Concer	ntric		BOM/Route		Grain			Over/Und	er tolerance	Set-up	
		Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incor	reci	Temperature/Cure	e
		Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	Inqualified	Part Lost/	Missing	Weld	
		Cuffs				Contamination	-	Instruct	tions Incomplete	/Unclear	Part Mov	ed	Wrong Stock Pulle	d:
		Crushing				Countersink		₹	ned/off center		Positione	d Wrong		
	Г	Heat Trea				Cut Too Short	Г	Mislabe		ļ	Power Lo	ss/Surge	Other	
		Inspectio		Tube		Drawing		Misrea		•		-		
		Marks/Cl	-			Drill Holes		Off-set			<del></del>			
	$\vdash$	- ·	Sequence			Finish		-i	Calibration					
	Г	-	vist in Tub			Fit/Function		4	Sequence					

DART AEROSPACE LTD	Work Order:	193376
Description: Joggle Bracket	Part Number:	D3580-3
Inspection Dwg: D3580 Rev: C		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.194	+0.005/-0.001	0.1957	_		ν	Jamo)
0.294	+/-0.010	0.294	_		U	
1.75	+/-0.030	1.75"			J	
0.75	+/-0.030	6.75	_		V	
0.050	+/-0.010	0.048"			V	
	-		-			
				·		
	DAS		- DÁS			

Measured by: 9-89 Audited by: 9-89 Preliminary Approval:

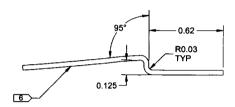
Date: 14-10-2 Date: 16-16-2 Date:

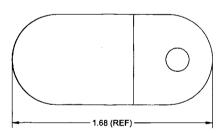
Rev	Date	Change	Revised by Approved
Α	14.07.14	New Issue	KJ <b>A</b>
			<del></del>

SHOP COPY **RETURN TO ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE **WORK ORDER** J 866/ 01

D

С





**D3580-1 JOGGLE BRACKET** 



С	UPDATED DWG FORMAT. ADDED D3580-3 (ZN 85-3) AND D3580-5 (ZN 85-4). ADDED SIDE VIEW TO D3580-1F (ZN 05-2) REMOVE POWDER COAT NEW ISSUE		14.02.12 07.07.09 07.05.15
В			
A			
REV.	DESCRIPTION	BY	DATE

ב ב						
	DESIGN	AK	DART AEROSPACE LTD			
	DRAWN	AK	HAWKESBURY, ONTARIO, CANADA			
	CHECKED	V\$	DRAWING NO.	REV. C		
5	MFG. APPR.	JLM	D3580	SHEET 1 OF 4		
2	APPROVED	HS "/	TITLE	SCALE		
ב	DE APPR.	DS <b>C</b>	JOGGLE BRACKET	NTS		
(	DATE 14.0	2.12	COPYRIGHT © 2007 BY DART AEROSPACE LTD  THIS DOCUMENT BY PROVIEW AND COMPEDENTLY AND IS SUPPLIED ON THE EXPRESS CONCENTION THAT IT IS HOTT TO BE USED FOR ANY PURPOSE OF COMPED ON COMPANIANTED TO ANY OTHER PRESIDENT WITHOUT			

NOTES:
1) MATERIAL: MADE FROM D3580-1F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON THE UNDERSIDE OF THE PART AS INDICATED
7) WEIGHT: 0.01 lbs

7

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